

# Work Order ID 51670

August 27, 2009 8:40:58 AM



Page 1

Item ID: D3641-1

Revision ID: B

Item Name: Cover

Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/11/09

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *P*

QC:

Date: *08-27*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3641

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*SB 09/09/11*



*HB 9-9-9*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*=> S 09/09/11*



*HB 9-9-9*

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51670

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Item ID: D3641-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 8/27/09 Start Qty: 10.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3641-1

0.00

0.00

SB 09/09/14

10

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 09/09/14

410

4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

27 09/09/15

410

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 51670**

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Page 3

Item ID: D3641-1

Accept

Revision ID: B

Item Name: Cover

Setup Start

Stop

Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/11/09

Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BL 09-09-15

(10)

170

Identify as per dwg & Stock Location: I60

0.00



Packaging

Memo

0.00

Packaging

9/9/16 Cox SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/16 AJ

u 9.9.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 27, 2009 8:40:57 AM

Page 1

Work Order ID: 51670

Parent Item: D3641-1RevB

Parent Item Name: Cover

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	75.9300	8.4074			



5052-H32 .032 Sheet

B 9-9-9

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	75.93
100470	6
103321	3
105998	10.5
108462	13
109478	4.32
111448	26.43
15031	12.68

105998 X 4 = 3.3629

111448 X 3 = 2.5222

15031 X 3 = 2.5222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

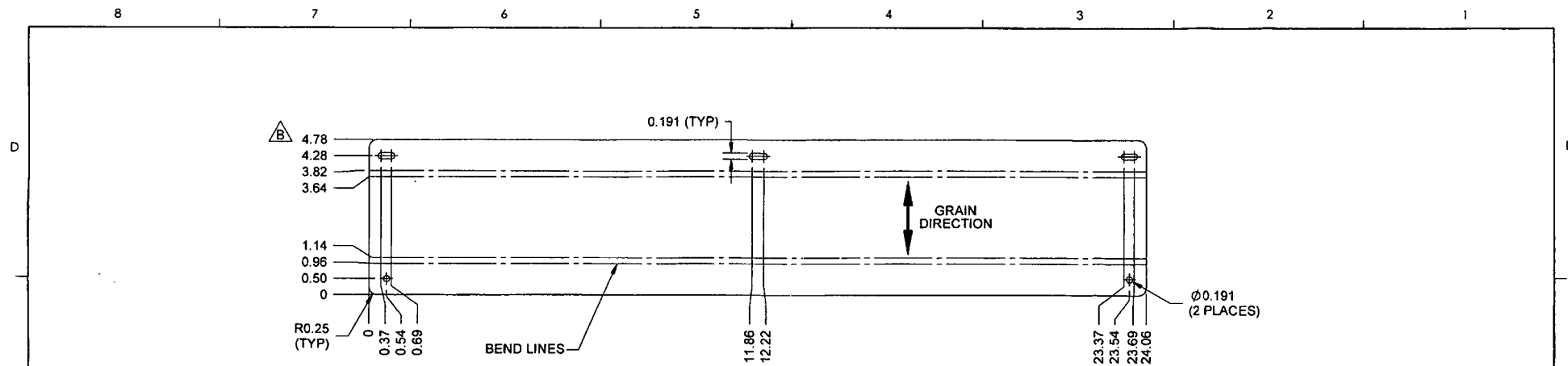
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

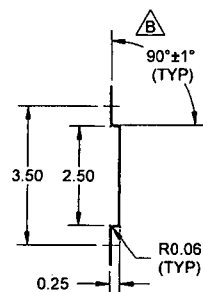
**NOTE:** Date & initial all entries







**D3641-1F FLAT PATTERN**



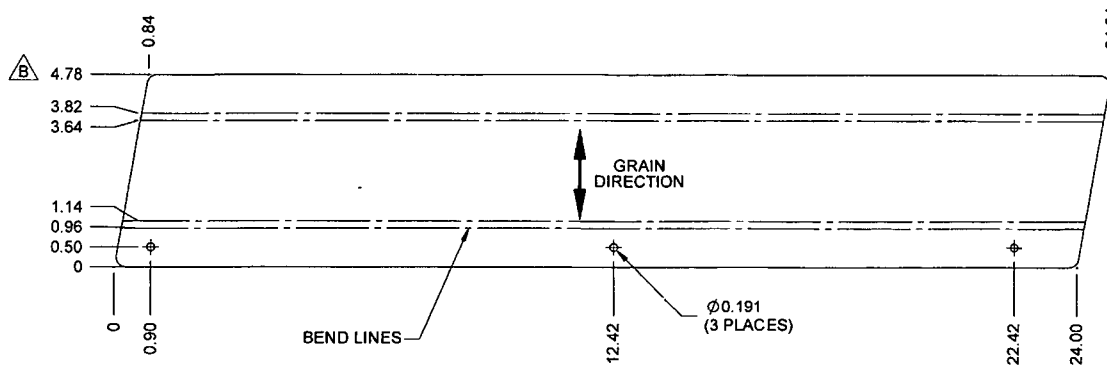
**D3641-1 COVER  
(REPLACES GENEVA P/N G10606-3/-6)**

OK for -1  
PH 09.01.20  
UNDER REVIEW  
ASS 09.07.23  
See NCD 09.07.16  
See ECU 09-635

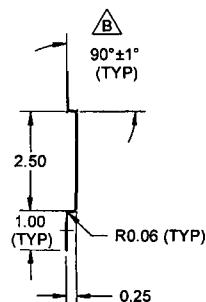
RELEASED  
07.11.14

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.35 lbs

B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. D3641 REV. B SHEET 1 OF 1 TITLE COVER SCALE 1:3 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONSENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	LE		
CHECKED	RS		
MFG. APPR.	LS		
APPROVED	MS		
DE APPR.	MS		
DATE	07.10.16		



**D3641-3F FLAT PATTERN**





**D3641-3 COVER  
(REPLACES GENEVA P/N G10606-5)  
D3641-4 OPPOSITE  
(REPLACES GENEVA P/N G10606-4)**

OK for -1  
00.06.27  
UNDER REVIEW  
JSS 07.07.27  
See NCR 09-076  
See ECN 09-635

RELEASED  
07.11.17

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. E
MFG. APPR.		D3641	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	1:3
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